

Work Order ID 99129

March-28-13 12:47:08 PM

99129

Page 1

Item ID: D3916-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib Assembly

Start Date: 3/27/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/27/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *1304-02* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3916

A

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- Cut tube 50"
2- Bend tube with manuel pipe bender as per DT9567
*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
3- Trim access tube material to finish size as per dwg D3916
4- Drill and chamfer holes as per dwg D3916-1 using DT9605.

SAT 13-04-29 (u)

(4) 13-04-30 PD

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Memo

0.00

Quality Control

(4) 13-04-30

Work Order ID 99129

99129

Page 2

March-28-13 12:47:08 PM

Item ID: D3916-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rib Assembly

Start Date: 3/27/13

Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/27/13

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

107

Weld per dwg A/R S.S. rod Batch: M123823

0.00

107

Large Fab

Memo

0.00

Large Fab

1- weld bushing as per dwg D3916
2- grind welds flush

④ 13-04-30 PD

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

④ 13-4-30

4

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

④ 13-4-30

4

Work Order ID 99129

March-28-13 12:47:08 PM

99129

Page 3

Item ID: D3916-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib Assembly

Start Date: 3/27/13 Start Qty: 8.00 *8*

Cust Item ID:

Required Date: 3/27/13 Req'd Qty: 8.00 *8*

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: Date:

Tooling: Date:

Stop *NR2*

QC: Date:

SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 Identify as per dwg & Stock Location: WA 4

0.00

130

0.00

Packaging

Memo

Packaging

140 QC21- Final Inspection - Work Order Release

0.00

140

0.00

QC

Memo

Quality Control

mf
13-5-01

Picklist Print

March-28-13 12:47:07 PM

Page 1

Work Order ID: 99129

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Start Date: 3/27/13

Required Date: 3/27/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC
verified by:EC

IPP Rev:B as per dwg revA 10.03.15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 Bushing		Manufactured	No			100	Each	146.0000	7	56	23	13-04-30	PD

Location

Loc Qty

Loc Code

WA004

146

66489

1

79213

1

83464

7

86550

20

88236

44

89780

11

90786

22

98089

40

M304TS0.750W.049

Purchased

No

304 SQ Tube .75x.75x.049W

100

f

639.0609

4.166

35.082105

51.2

13-04-29

Location

Loc Qty

Loc Code

MAT017

459.1583

124492

459.1583

WA006

179.9026264

123219

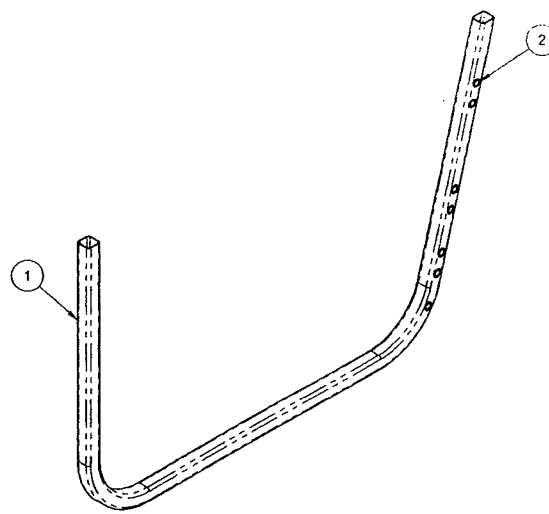
49.7359405

123484

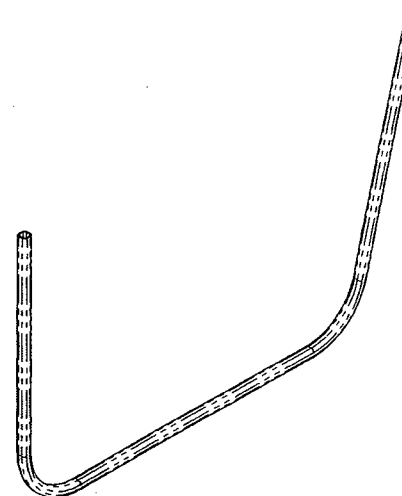
130.166686

17.5411

ITEM	QTY	P.N	DESCRIPTION
	041		
	X	D3916-041	RIB ASSY
	1	D3916-5	RIB
	7	D3916-1	BUSHING



D3916-041 RIB ASSY

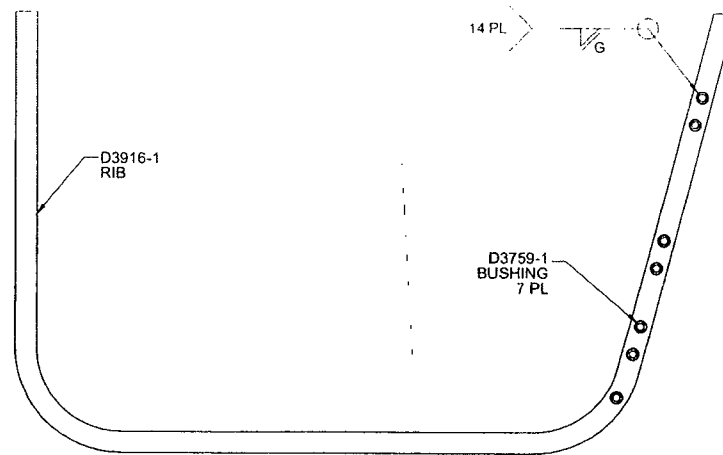


D3916-5 LIGHT RIB

99129 MJS
1304-02

OK 10.12.21
~~UNDER REVIEW~~
10.10.11
ADDITION OF HOLE + BUSHINGS
ON D3916-041 RIBS.
RELEASED
2010-03-12
JWP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.	J	D3916	SHEET 1 OF 4
APPROVED	JWP	TITLE	SCALE
DE APPR.	JWP	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



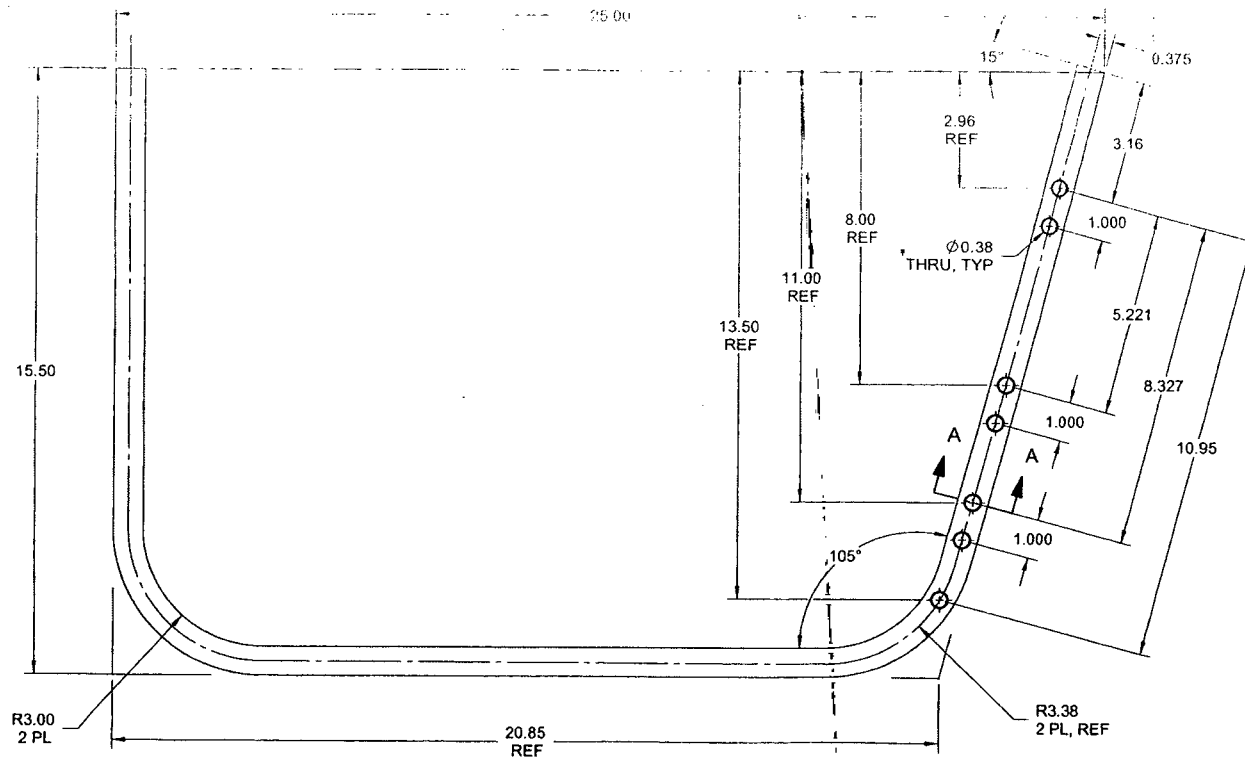
D3916-041 RIB ASSY

RELEASED
2010-03-12
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	







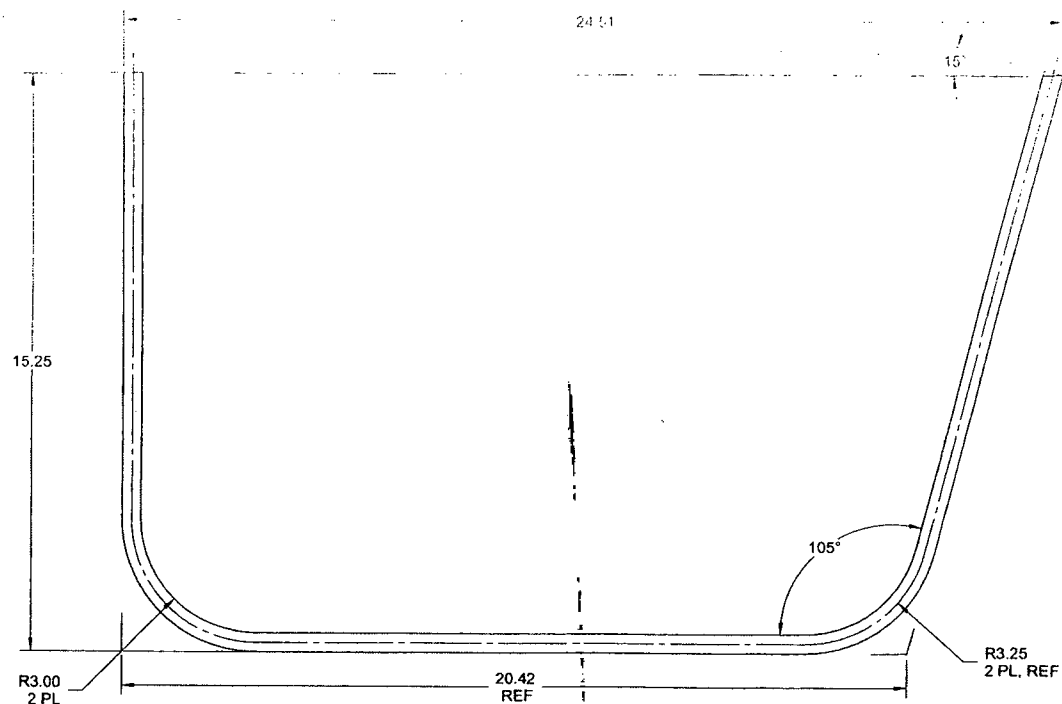
9 D3916-1 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

RELEASED
2010-03-12

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. /
MFG. APPR.		D3916	SHEET 3 OF
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			



9 D3916-5 LIGHT RIB

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	